

FIG. 1

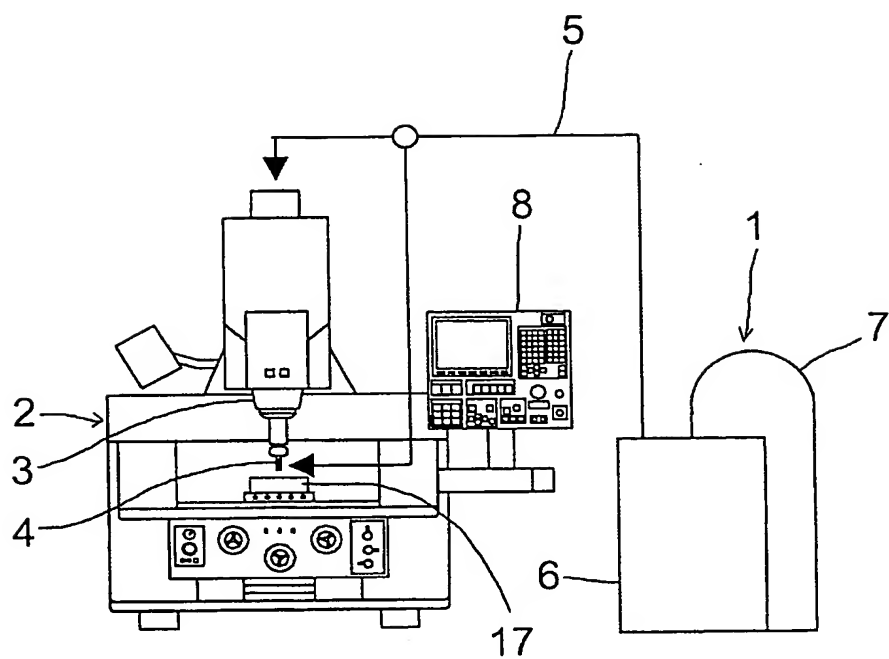
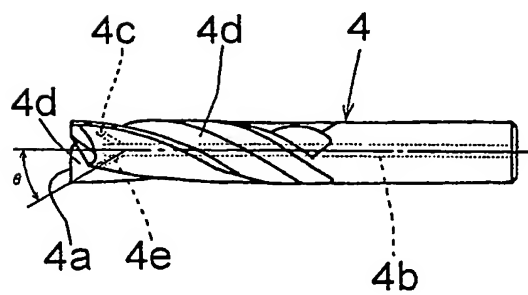
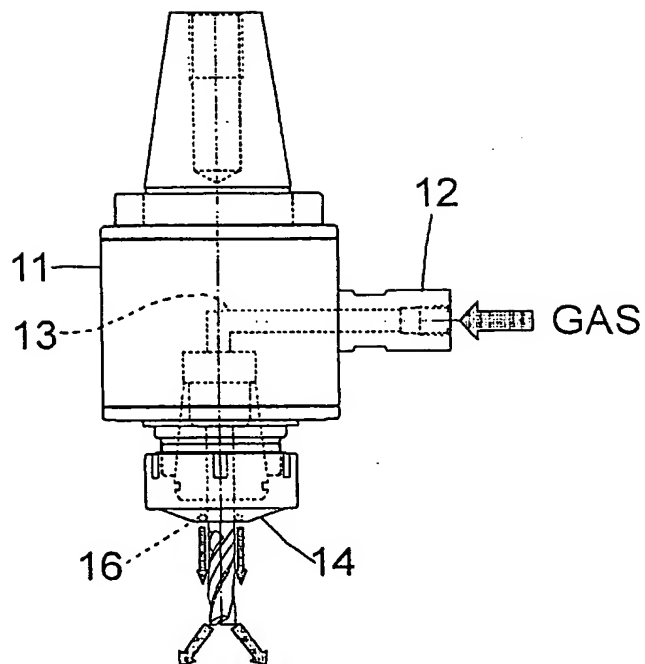


FIG. 2



F I G. 3



F I G. 4

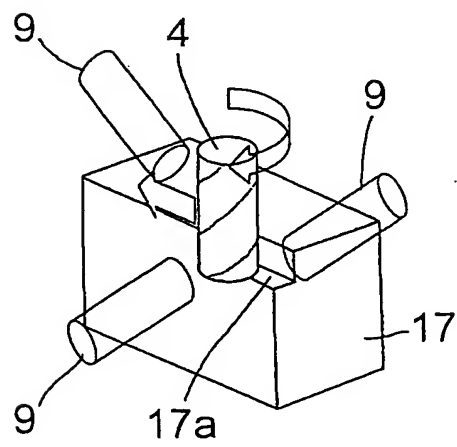


FIG. 5

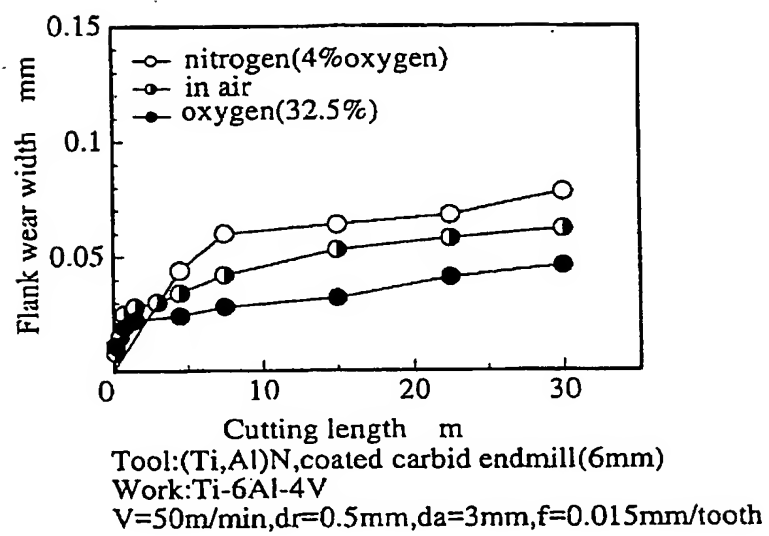
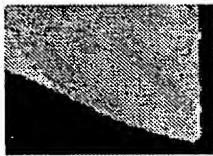


FIG. 6A

Nitrogen
(4%O₂)

(a)



(b)



(c)

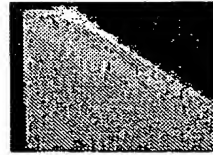
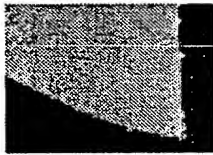


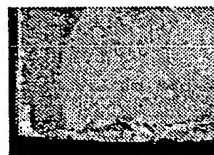
FIG. 6B

Air
(20.9%O₂)

(a)



(b)



(c)

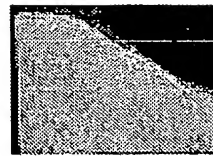
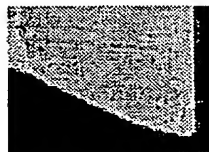


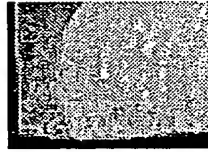
FIG. 6C

Oxygen
(32.5%O₂)

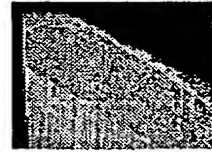
(a)



(b)



(c)



Tool: (Ti,Al)N coated carbide end mill (ϕ 6mm)

Work: Ti-6Al-4V

V=50m/min, dr=0.5mm, da=3mm, f=0.015mm/tooth, L=30m

FIG. 7A

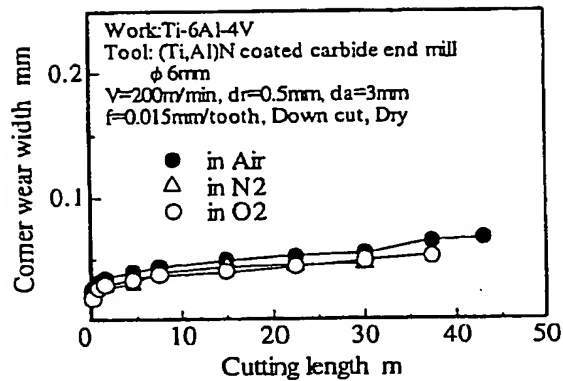


FIG. 7B

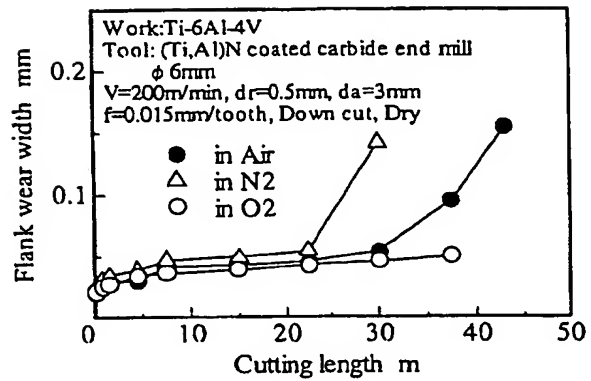


FIG. 8A

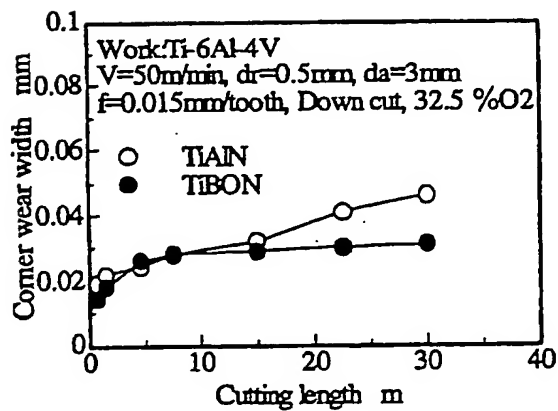


FIG. 8B

